

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000887**Date Inspected:** 19-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Lay Tou & Li Xiu Yang
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: 77 meter mock up & Floor Beams

Bridge No: 34-0006**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

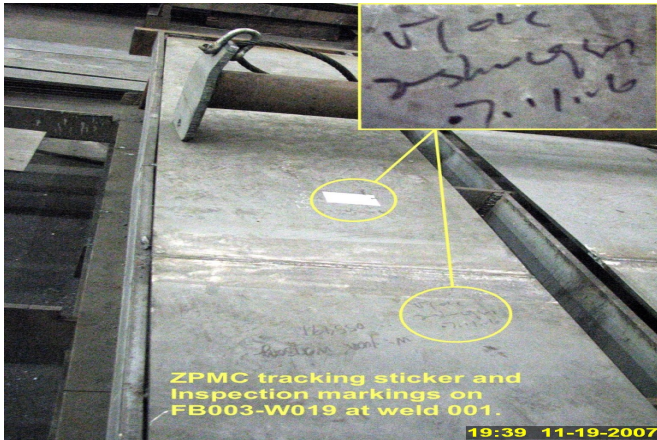
Bay 2: The QA inspector observed the ZPMC technician Zhou Dong Yun conducting magnetic particle testing (MT) on partial joint penetration (PJP) root welds. Upon completion of the MT, the ZPMC liason Li Xiu Yang (Tom) relayed information to the QA inspector that all root welds were acceptable. The QA inspector also noted that "MTOK" markings have been made, indicating that welds were visually acceptable and no relevant MT indications were observed by the ZPMC technician. The QA inspector then conducted 10% verification MT of the PJP root welds. The QA inspector noted that weld tabs are not placed at the weld terminations at this time. At the time of examination, the QA inspector did not observed any relevant MT indications on any of the 6 PJP root welds. See the attached TL-6028 report for more information.

Bay 7: The QA inspector observed part FB003-W019. The ZPMC liason Lay Tou informed the QA inspector that ultrasonic testing (UT) has been conducted by ZPMC technicians and the welds #001 & #006 are acceptable. The QA inspector noted that white ZPMC tracking stickers adjacent to the welds do not appear to have the NDE portion filled out. The QA inspector also noted that it is very difficult to discern the writing but there appears to be "UTOK" written at a separate location near each weld. The QA inspector asked the ZPMC liason why the tracking sticker was not filled in for the NDE portion. The ZPMC liason remarked that he did not know why the tracking sticker was not completed and he confirmed that "UTOK" was visible near both welds. The QA inspector conducted 10% verification UT on welds 001 & 006. No rejectable indications were noted at the time of

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examination. See the attached TL-6027 report for more information.



Summary of Conversations:

The QA inspector Scott Croff had conversations with the ZPMC liasons Zhou Dong Yun and Lay Tou regarding the work in progress, as described above. The QA inspector was notified of the completion status as the ZPMC technicians were informing the ZPMC liason directly. After completion of the QA inspectors' verification of the parts/welds, the ZPMC liasons were informed of the observed conditions.

The QA inspector Scott Croff had general conversations with the QA inspectors Bruce Berger and Roscoe Dixon. The QA inspectors discussed the above mentioned observations and what is being fabricated at other locations. There were no other notable conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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